

Work Order ID 83856

83856

Page 1

April-26-12 2:26:14 PM

Item ID: D3278-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support Assembly

Start Date: 26/04/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/26 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3278	Rev C
-------	-------

100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Rivet spacers with support as per Dwg D3278.								

40x

[Signature]
12/06/04

110		0.00							
110	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

40

[Signature]
12/06/04

120		0.00							
120	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Assemble support as per Dwg D3278. ***DO NOT TIGHTEN BOLTS*** Identify as D3278-041								

40

[Signature]
12/06/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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40

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 781

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

Watts
740

9/24/10 (40)

12/6/10

MF
1206-05

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Picklist Print

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Page 1

Work Order ID: 83856

83856

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: A04.04.19New issueKJ/JLM

IPP B 07.08.21 Chg rivet per PAR185 EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3278-1 *D3278-1* Support		Manufactured	No			100	Each	21.0000	1	40	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		21							
				73412		1							
				80579		20							
D3278-2 *D3278-2* Support		Manufactured	No			100	Each	21.0000	1	40	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		1							
				74879		1							
				GA		20							
				80580		20							
D3278-3 *D3278-3* Spacer		Manufactured	No			100	Each	31.0000	1	40	**		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		31							
				70984		2							
				77061		14							
				80166		15							

EP 12/06/04
B84101
200

EP 12/06/04
B84102
200

EP 12/06/04
B84016
120

W/O:		WORK ORDER CHANGES					
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Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 40.00

Required Qty: 40.00

MS21042L4

Purchased

No

100

Each

5,796.000

2

80

MS21042L4

Nut

**

EB 12/06/04

Location

Loc Qty

Loc Code

ST300

5796

116188

5

119017

4

119075

787

121011

2000

121444

3000

80

AN4-13A

Purchased

No

120

Each

969.0000

2

80

AN4-13A

Bolt

**

EB 12/06/04

Location

Loc Qty

Loc Code

ST357

969

119449

39

120187

19

120422

11

120770

400

121162

500

80

AN960JD416

NAS1149D0463J

Purchased

No

120

Each

10.0000

4

160

AN960JD416

Washer

**

EB 12/06/04

Location

Loc Qty

Loc Code

ST351

10

116289

10

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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83856

Parent Item: D3278-041

D3278-041

Parent Item Name: Support Assembly

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 40.00

Required Qty: 40.00

D2230-1

Manufactured No

120

Each

30.0000

2

80

D2230-1

Lug

**

Location

Loc Qty

Loc Code

ST

4

78596

4

ST480

26

67826

6

70974

3

80008

17

MS20426AD3-6

Purchased

No

120

Each

4,697.000

4

160

MS20426AD3-6

Rivet

**

Location

Loc Qty

Loc Code

ST316

4697

105055

107

116289

1974

120123

2616

EP 12/06/04

B83273
80x

EP 12/06/04

160

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Shop Packet Print

Page 3

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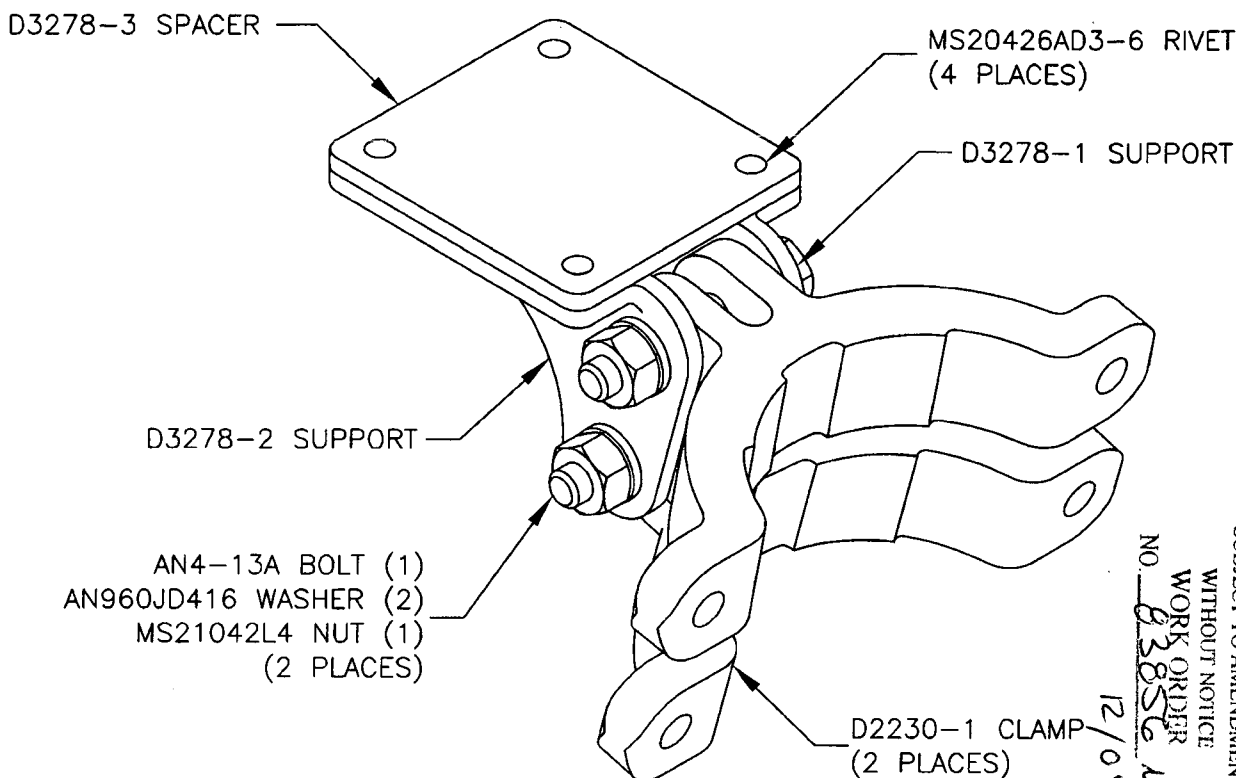
NOTE: Date & initial all entries



DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-08

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83856 MCT
12/07/24

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

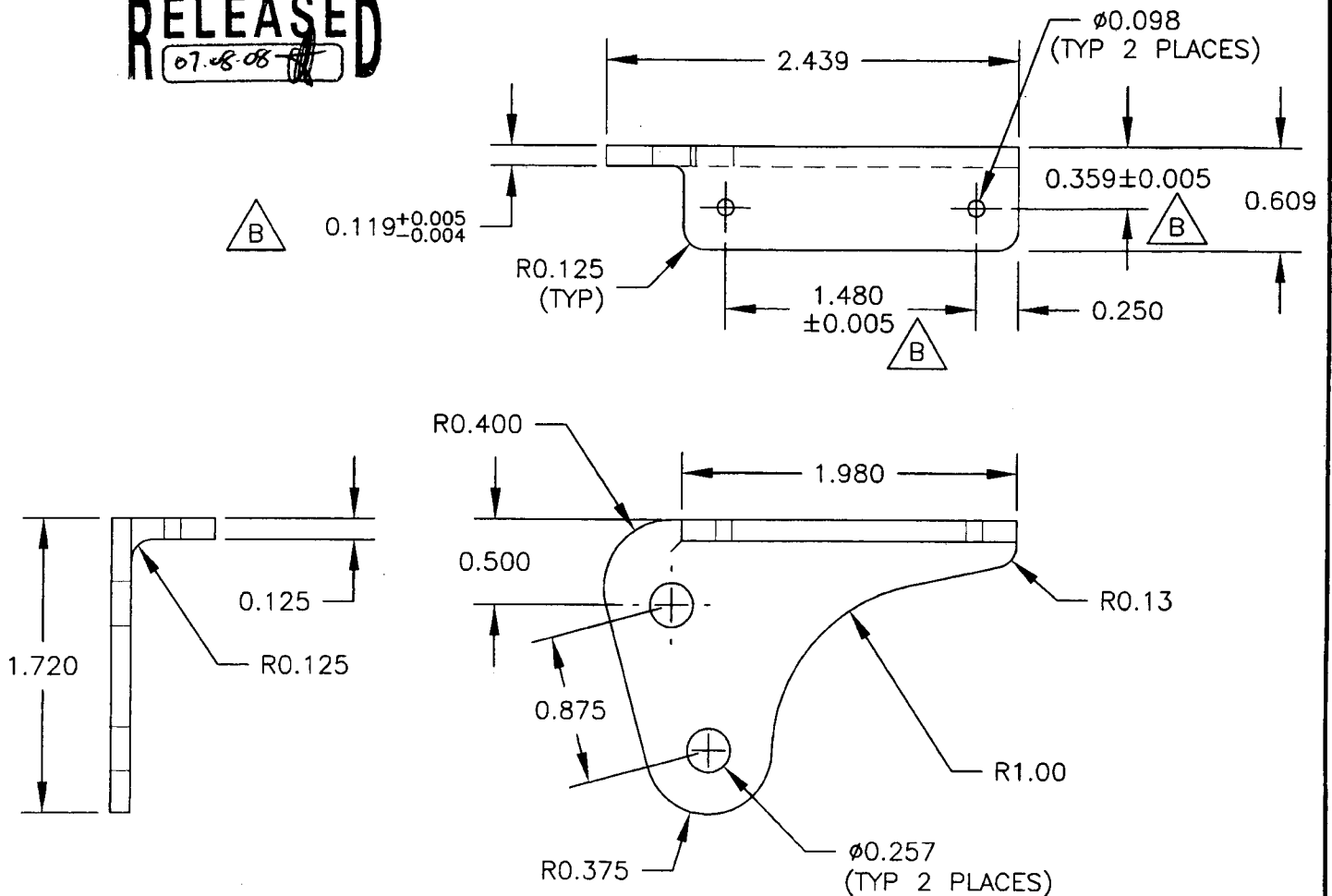
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>9P</i>	DRAWN BY <i>SC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

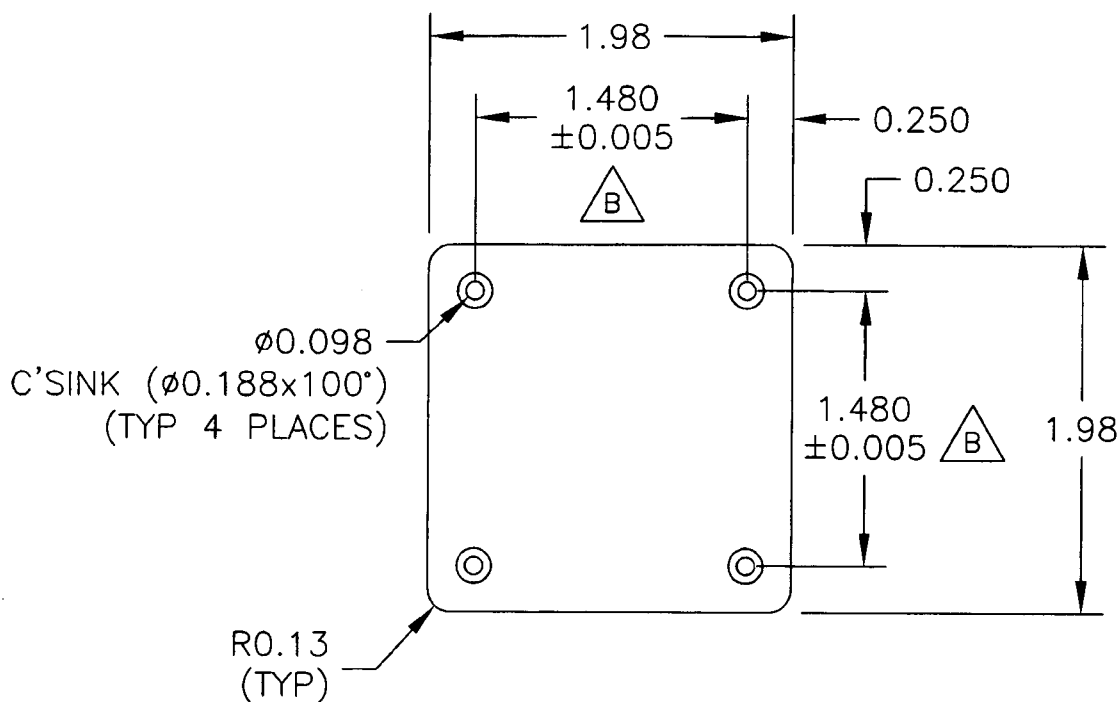
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NOTE: Date & initial all entries



DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08



D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

038856

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